

5/23

SPLT

DART AEROSPACE LTD	Work Order:	23347
Description: Maintenance Step, LH	Part Number:	D3436-043/-041
Dwg: D3436 Rev. A	Qty:	9 10
		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																				
1	DC	Issue Traveler	HA	05.06.09	10																				
2	WS	Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>D3436-1</td> <td>Clamp</td> <td>M17679</td> </tr> <tr> <td>1</td> <td>D3436-3</td> <td>LH Step</td> <td>M17679</td> </tr> <tr> <td>4</td> <td>D3436-5</td> <td>Bushing</td> <td>31557 M17679</td> </tr> <tr> <td>1</td> <td>D3436-7</td> <td>Cap</td> <td>B23358</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	1	D3436-1	Clamp	M17679	1	D3436-3	LH Step	M17679	4	D3436-5	Bushing	31557 M17679	1	D3436-7	Cap	B23358	CPL	05.08.04	10
Qty	Part Number	Description	Batch																						
1	D3436-1	Clamp	M17679																						
1	D3436-3	LH Step	M17679																						
4	D3436-5	Bushing	31557 M17679																						
1	D3436-7	Cap	B23358																						
3	WS	Weld bushings and clamp using welding Jig DT8772 and Dwg D3436 <i>D3436-5 DEVIATION: CAN USE BUSH WALL AND ENSURE BOLT FIT.</i> <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>A/R</td> <td>N/A</td> <td>4130 Welding Rod</td> <td>M9430</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	A/R	N/A	4130 Welding Rod	M9430	CPL	05.08.04	10												
Qty	Part Number	Description	Batch																						
A/R	N/A	4130 Welding Rod	M9430																						
4	WS	Weld left step using welding Jig DT8773 and Dwg D3436 <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>A/R</td> <td>N/A</td> <td>4130 Welding Rod</td> <td>M9430</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	A/R	N/A	4130 Welding Rod	M9430	CPL	05.08.04	10												
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A/R	N/A	4130 Welding Rod	M9430																						
5	WS	Weld cap as per Dwg D3436 <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>A/R</td> <td>N/A</td> <td>4130 Welding Rod</td> <td>M9430</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	A/R	N/A	4130 Welding Rod	M9430	CPL	05.08.04	10												
Qty	Part Number	Description	Batch																						
A/R	N/A	4130 Welding Rod	M9430																						
6	WS	Slit part on bandsaw as per Dwg D3436 Identify as D3436-043 & -041 Dwg Rev: A	CPL	05.08.04	10																				
7	QC9	Inspect welds and work to Step 6	2	05.08.11	10																				
8	GA	Deburr	CPL	05.07.11	10																				
9	FP	Powder Coat Gloss White (Ref: 4.3.5.2) as per QSI 005 4.3	FC	05.09.04	10																				
10	FP	Apply black anti-skid paint as per Dwg D3436 and QSI 005 4.4	FC	05.09.12	10																				
11	QC3	Inspect Powder Coat	IM	05.09.13	10																				
12	GA	Install pad using contact cement as per manufacturer's instructions and Dwg D3436 Dwg Rev: A Pick: <table border="1"> <thead> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> </thead> <tbody> <tr> <td>2</td> <td>D3436-9</td> <td>Pad</td> <td>B20359</td> </tr> <tr> <td>A/R</td> <td>N/A</td> <td>Contact Cement</td> <td>M16194</td> </tr> </tbody> </table>	Qty	Part Number	Description	Batch	2	D3436-9	Pad	B20359	A/R	N/A	Contact Cement	M16194	SP	05/09/15	10								
Qty	Part Number	Description	Batch																						
2	D3436-9	Pad	B20359																						
A/R	N/A	Contact Cement	M16194																						
13	QC5	Inspect work to Step 12	2	05.09.15	10																				
14	ST	Identify and Stock	CPL	05/09/23	9																				
15	AC	Cost / part: 48.47 28.93	S45	05.09.26	9																				
16	DC	Close W/O 48.47 28.93 Inspect Level 21	DP	05/09/26	9																				

PTO

Rev	Date	Change	Revised By	Approved
A	05.05.11	New Issue	KJ/JLM	

RELEASED
05/05/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-05-15	9	minor touch-up on ends of 2 steps, powder coat a little too thin.	<i>JB</i> Design	Touch-up with Immwhite lightly.	<i>J</i> 05-05-15	<i>J</i> 05-09-15	<i>MD</i> 05-09-15	<i>J</i> 05-09-15

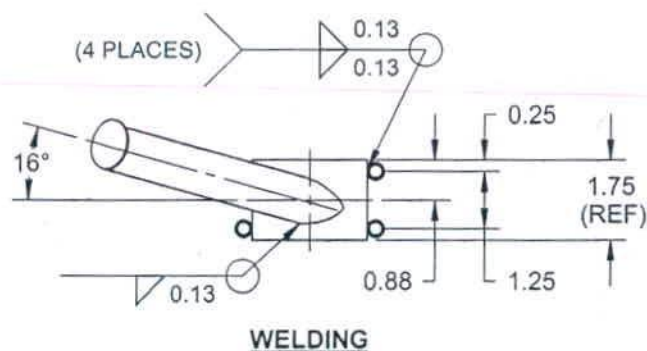
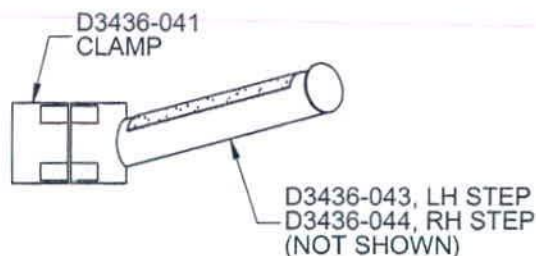
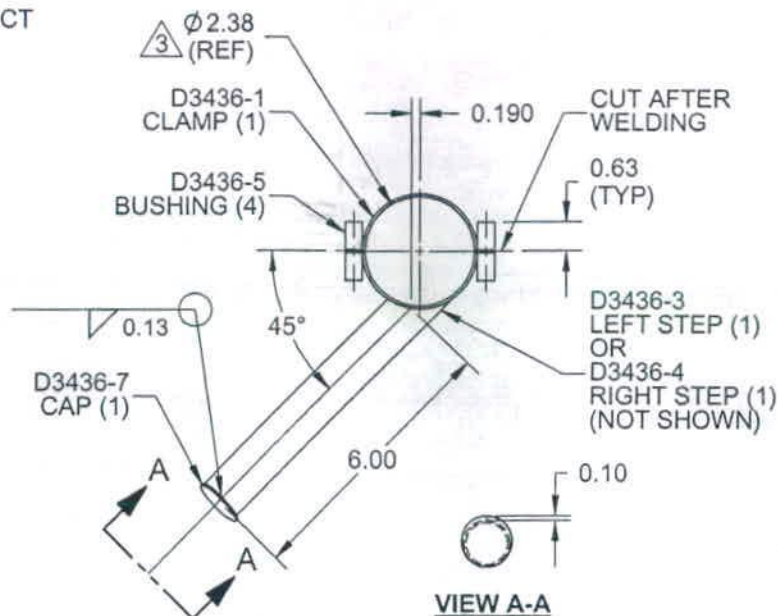
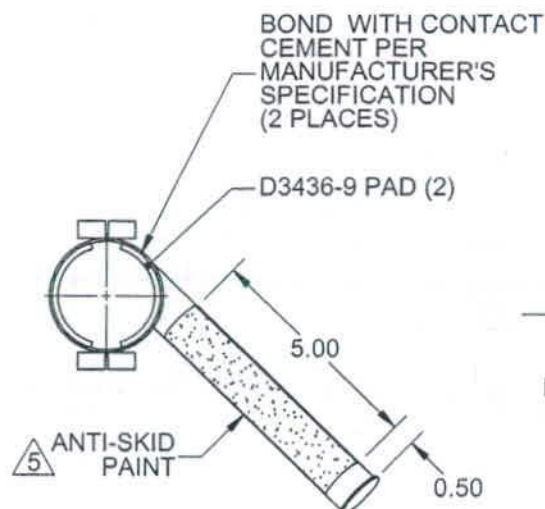
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: *DS* Date: 05/09/20

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



DESIGN MB	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3436	REV. A SHEET 1 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:4
A	05.04.28	NEW ISSUE	



NOTES:

- 1) POSITION PARTS AS PER JIGS DT8772 AND DT8773
- 2) WELD PER DART QSI 004
- 3) FILLET BOTH TOP AND BOTTOM EDGES OF CLAMP ALONG 2.38 I.D. SECTION TO 0.03 RADIUS TO PREVENT SCORING AND SCRATCHING OF SKID CROSS TUBE
- 4) FINISH: POWDER COAT WHITE GLOSS (4.3.5.2) PER DART QSI 005 4.3
- 5) APPLY BLACK ANTI-SKID PAINT AS SHOWN PER DART QSI 005 4.4
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES

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WORK ORDER

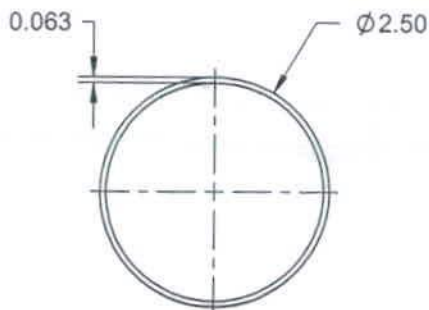
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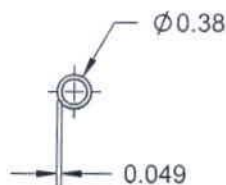
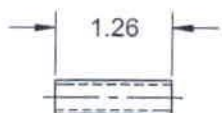


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3436	REV. A SHEET 2 OF 4
DATE 05.04.28	TITLE MAINTENANCE STEP		SCALE 1:2



D3436-1 CLAMP

- 1) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T2500W063)



D3436-5 BUSHING

- 2) MATERIAL: AISI 4130N STEEL TUBING PER MIL-T-6736, AMS 6371, 6360, 6361, 6362, 6373 OR 6374 (REF. DART SPEC. M4130N-T0375W049)

D3436-1/ -5, GENERAL NOTES:

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) ALL DIMENSIONS ARE IN INCHES
5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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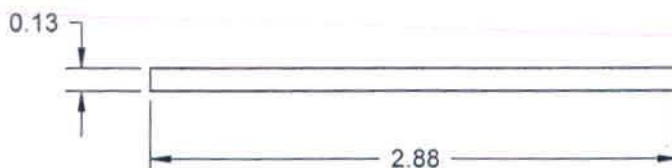
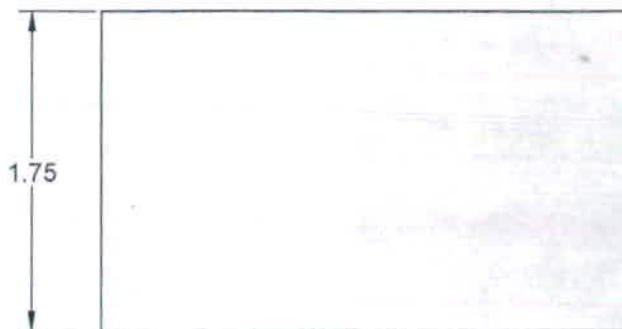
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3436	REV. A SHEET 4 OF 4
DATE 05.04.28		TITLE MAINTENANCE STEP	SCALE 1:1



D3436-9 PAD

NOTES:

- 1) MATERIAL: 60 DUROMETER NEOPRENE SHEET, 1/8" THICK
(REF. DART SPEC. M-NEO60-S.125)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 17, 2005
10:51 am

Work Order No : 0023347
Project Name : D3436-043
Project For : WK523
Work Order Type : Main
Main WO Number :
House Part Number : D3436-043
Description : LH Step
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 05-17-05
Est Finish Date : 06-09-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Mark Up : 0.000%
Actual Mark Up : 0.000%

\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

May 17, 2005
10:51 am

233475

Work Order No : 0023346
Project Name : D3436-041
Project For : WK523
Work Order Type : Main
Main WO Number :
House Part Number : D3436-041
Description : Clamp Assembly
Manufactured : Yes
Amount Req'd : 20
Amount Done : 0
Start Date : 05-17-05
Est Finish Date : 06-09-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

Cancel

	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Packaging Hours	0.00	0.00	0.00		
Packaging Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
CNC Hours	0.00	0.00	0.00		
CNC	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Mark up	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/ (Loss) :	0.00	0.00

CLOSE
05/05/02
SAR

